

Date: Friday, 5/25/2007 8:17:34 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MID TUBE ASSEMBLY
Job Number : 32591	
Estimate Number : 11446	
P.O. Number :	Part Number : D3391013
This Issue : 5/25/2007 S.O. No. :	Drawing Number : D3391 REV. <i>F6</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : <i>F6</i>
Previous Run :	Material :
Written By : <i>JA 07.05.28</i>	Due Date : 6/20/2007 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est. A 05.12.13 New Issue EC	
Est. B 06.02.09 Dwg rev.D EC	
Est Rev:06-03-28 Update Manufacturing Instructions JLM	
est rev D 07.03.14 dwg Rev F EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description
1	D2500-1-100	Extrusion

Batch

B24593

DP 7-7-13

2.0	D3391011	Fwd Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch:

N/A tube was scrap.

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Drill pilot holes including "B" holes using DT8796 as per Dwg D3391

3-Open float bag holes as per Dwg D3391

4-C'sink float bag holes as per Dwg D3391

5-Open remaining holes as per dwg D3391

6- Locate electric step holes *41.500"* from fwd end and drill using DT 8393

***** ensure step holes are on top of tube not bottom. Pat*****

CE

DP 7-7-13
DP 7-7-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:17:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32591

Part Number: D3391013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

- | | | |
|-----|---|--|
| 7- | Open electric step holes 0.332" per dwg D3391 (section L-L) | |
| 8- | Open electric step holes 0.250" per dwg D3391 (section M-M) | |
| 9- | Open electric step holes 0.250" per dwg D3391 (section LL-LL) | |
| 10- | Remove .030" from Fwd indexing Ridge as per Dwg D3391 | |
| 11- | Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391 | |
| 12- | Deburr | |
| 13- | Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.208" holes with paint marker | |
| 14- | Open wearplate holes of D3391-013 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 | |
| 15- | Open wearplate holes of D3391-013 assembly detail section H-H to Ø0.257" and c'sink (20 holes) as per Dwg D3391 | |
| 16- | Open .375" holes to .438" | |
| 17- | insert D3391-011 and clico in place with wearplate holes, transfer drill saddle holes as per dwg D3391. | |
| 18- | Deburr and blow out all chips from inside tube | |

DD
2-7-19
870

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Touch-up alodine in D3391-011

6.0

QC3

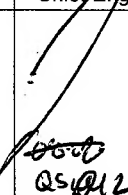

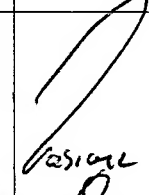
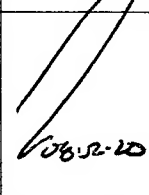
INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: PCR 08-13 PAR 08-04 NCR: Yes No DQA: 10 Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-02-20	3.0	New holes in incorrect location @ Ht. 12.5 location.	 08/02/21	See NCR / PAR See NCR 08-013 PAR 08-004 - Scrapped Destroy.	 08-02-20	 08/02/21	 08-02-20	

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:17:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32591

Part Number: D3391013

Job Number:



Seq. #: Machine Or Operation: Description :

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3389-1	Web	
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A/R

Sikaflex-241/-291

Sikaflex expire date:

Start: Time:

Finish: Time:

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

*****Ensure Web Alignment *****

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Use paint screws to mask inserts.

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

24	NAS1330C3KB116	Insert	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:17:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32591

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS1330C3KB166

INSERT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

24

NAS1330C3KB166

Insert

14.0

NAS1329C4KB140

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

NAS1329C4KB140

Insert

15.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H3L

Washer

16.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

4

AN960C10L

Washer

17.0

NAS1515H4L

Inventory



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H4L

Washer

18.0

AN960C416L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

4

AN960C416L

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: MID TUBE ASSEMBLY

Job Number: 32591

Part Number: D3391013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

MS27039C109

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039C1-09 Screw

20.0

MS27039C408

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039C4-08 Screw SCREW

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Assemble as per dwg D3391

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/2/22



2008/02/22

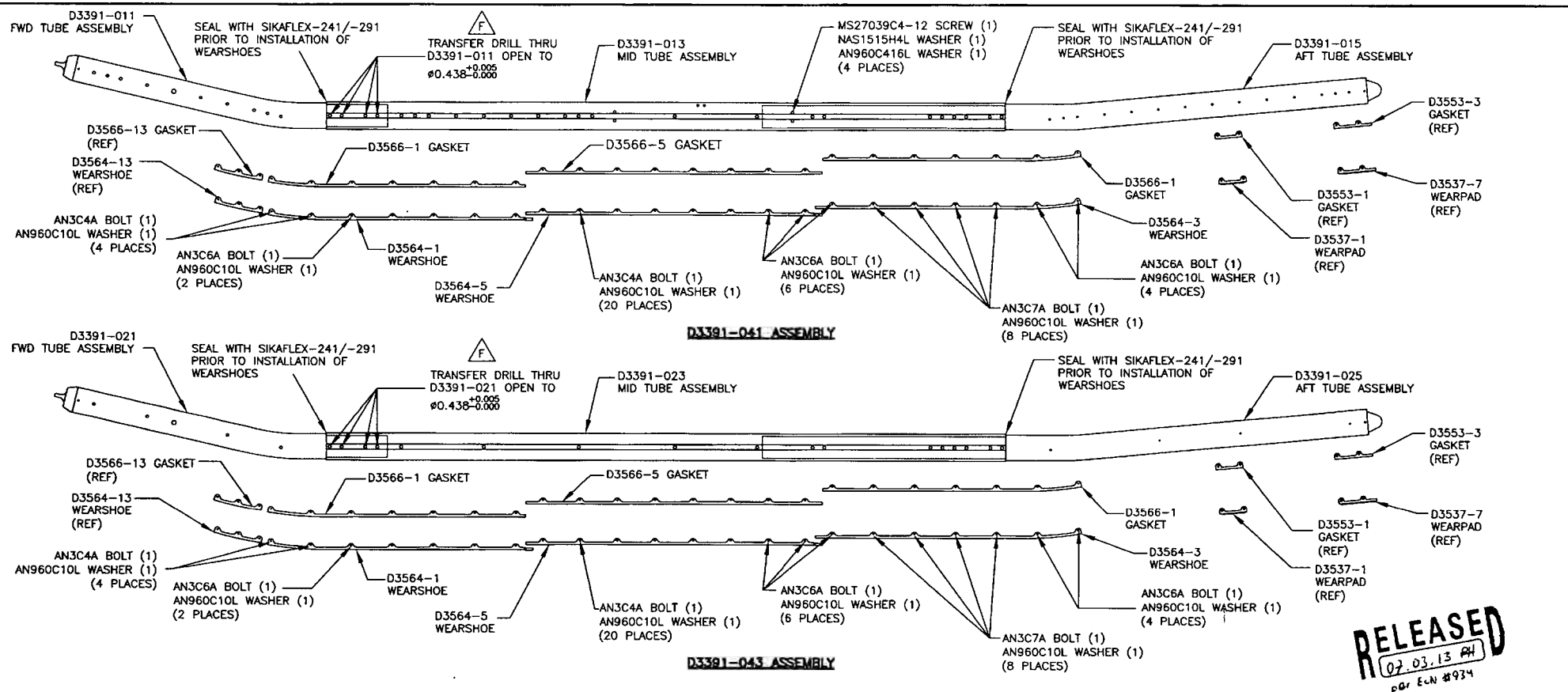
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.03.13 AH
per E-4 #934

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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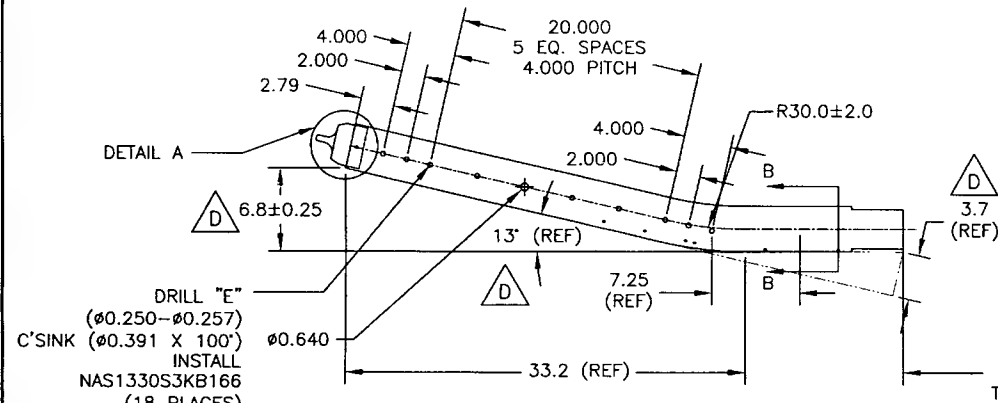
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DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, MA
DATE	07.01.18	DRAWING NO.	D3391	REV. F
		TITLE	412 FLOAT SKIDTUBE	SHEET 1 OF 5
		SCALE	NTS	

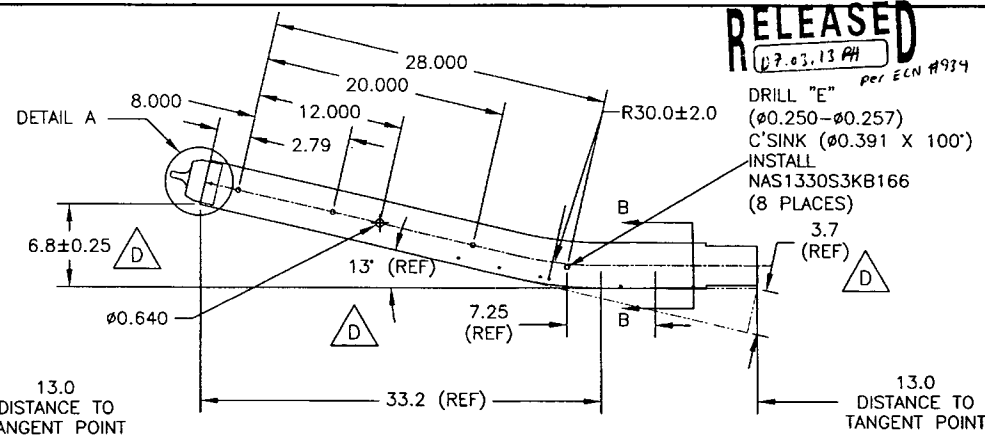
WORK ORDER
32591
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

RELEASED
07.03.13 AH

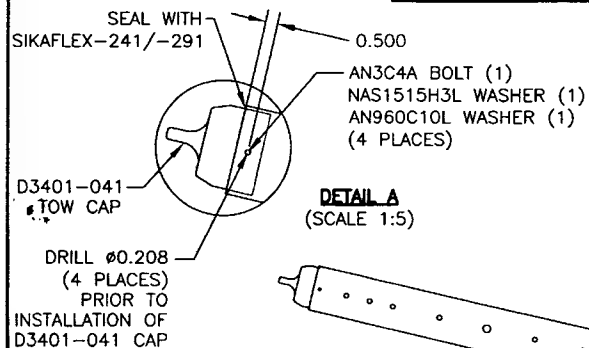
Per ECN #934



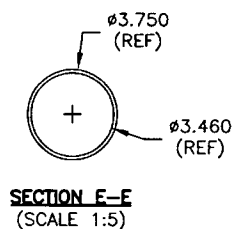
D3391-011 ASSEMBLY AND BENDING DETAIL



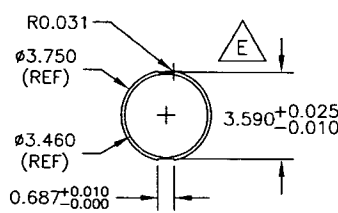
D3391-021 ASSEMBLY AND BENDING DETAIL



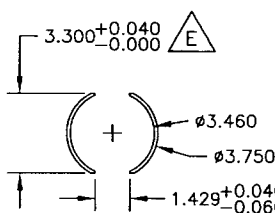
DETAIL A
(SCALE 1:5)



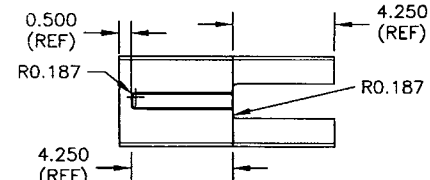
SECTION E-E
(SCALE 1:5)



SECTION D-D
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)



VIEW Z-Z
(SCALE 1:5)

D3566-13 GASKET

D3391-011/-021 WEARSHOE ASSEMBLY

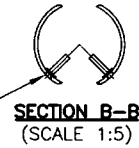
D3564-13 WEARSHOE

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(6 PLACES)

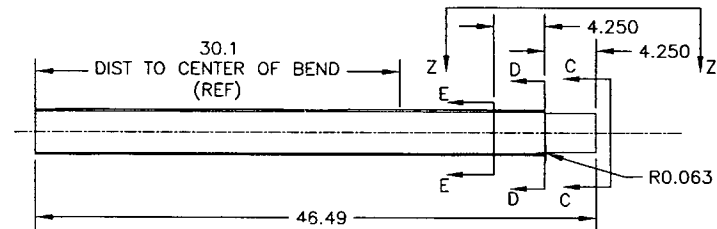
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

5
DRILL "E"
(Ø0.250-Ø0.257)
C'SINK (Ø0.391 X 100")
INSTALL
NAS1330S3KB166
(12 PLACES)



SECTION B-B
(SCALE 1:5)

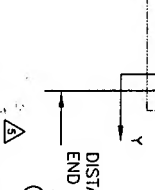
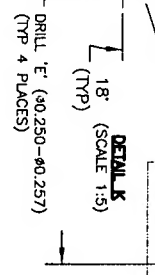
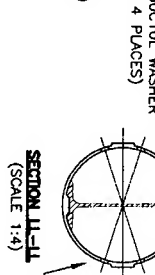
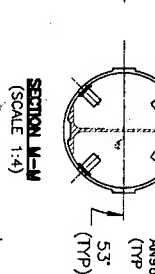
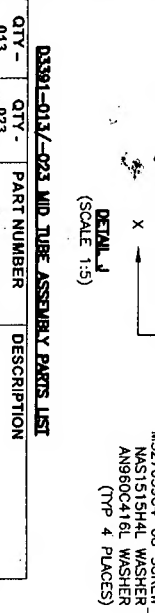
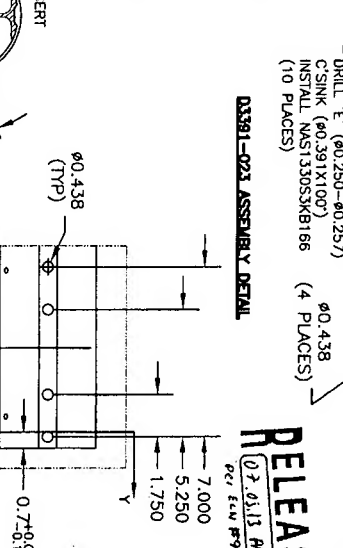
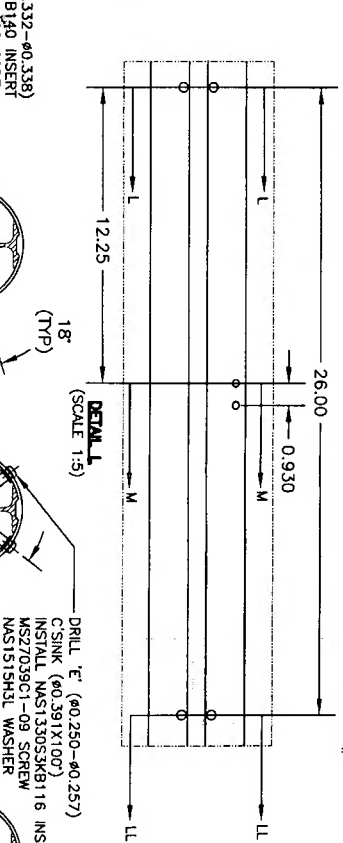
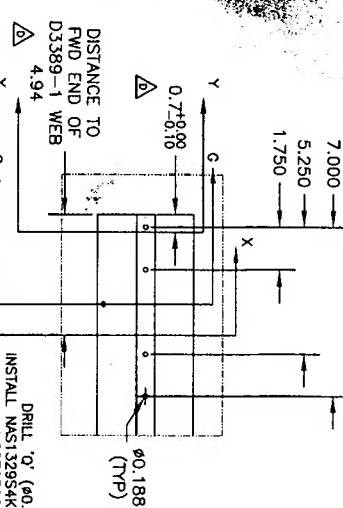
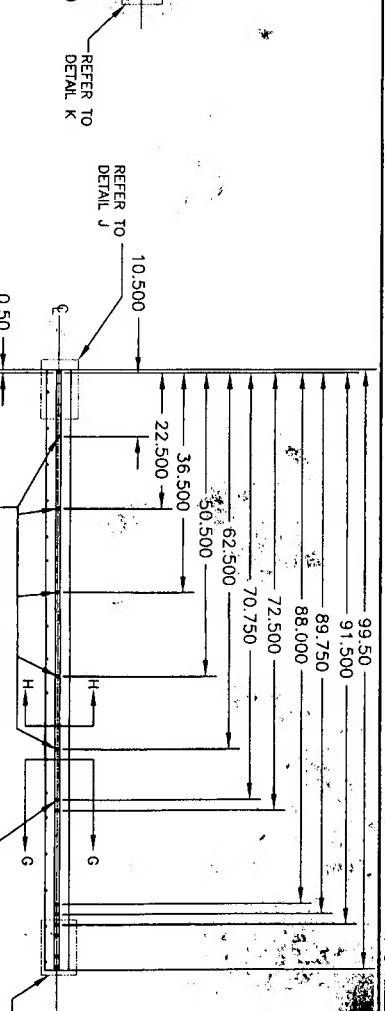
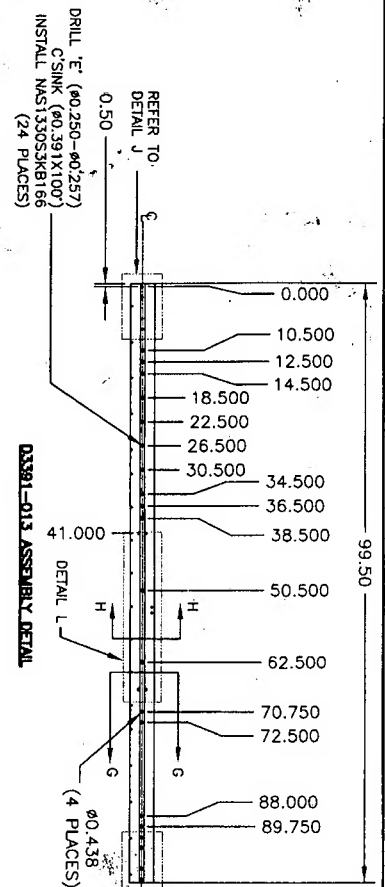


D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

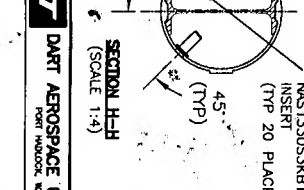
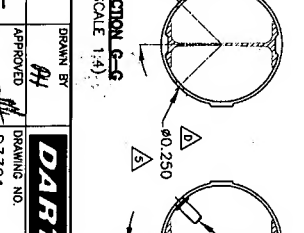
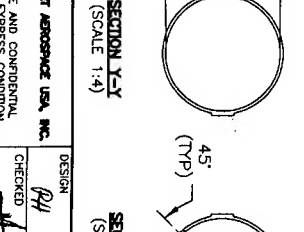
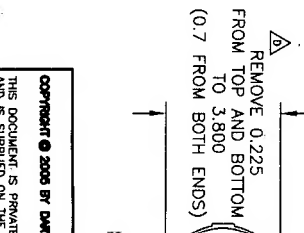
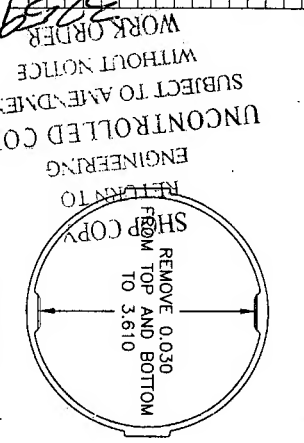
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3391
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 2 OF 5 SCALE 1:10

WORK ORDER
22591
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY





QTY -	QTY -	PART NUMBER	DESCRIPTION
013	023		
X		D3391-013	MID TUBE ASSEMBLY
X		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NA5133053KB116	INSERT (OR NA5133053KB116)
24	10	NA5133053KB166	INSERT (OR NA5133053KB166)
4	4	NA5132954KB140	INSERT (OR NA5132954KB140)
4	4	NA51515H3L	WASHER
4	4	AN960C10L	WASHER
4	4	AN960C416L	WASHER
4	4	MS27039C1-09	SCREW
4	4	MS27039C4-08	SCREW



1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAPLEX-241/-291 PER OSI 015

WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 FROM COPY

SECTION X-X (SCALE 1:2)
 REMOVE 0.030 FROM TOP AND BOTTOM TO 3.610

SECTION Y-Y (SCALE 1:4)
 REMOVE 0.225 FROM TOP AND BOTTOM TO 3.800 (0.7 FROM BOTH ENDS)

SECTION G-G (SCALE 1:4)
 45° (TYP)

SECTION H-H (SCALE 1:4)
 45° (TYP)

SECTION I-I (SCALE 1:4)
 45° (TYP)

013 023

07/01/18

412 FLOAT SKIDTUBE

120

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 PCF ECU 0934

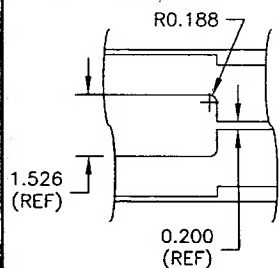
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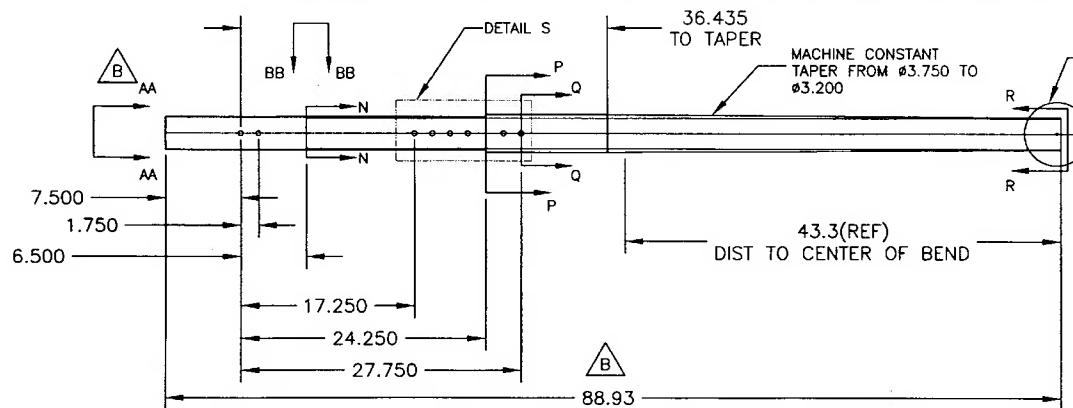
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 DART Aerospace USA, Inc.
 1001 WILSON, WA

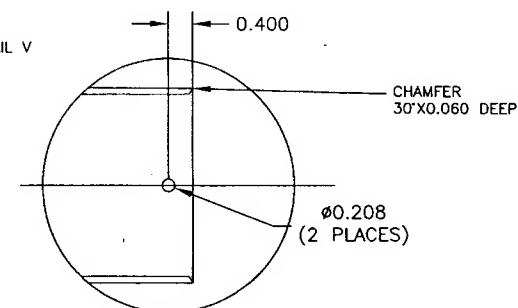
DRAWING NO: D3391
 SHEET 3 OF 5
 SCALE: 1:20



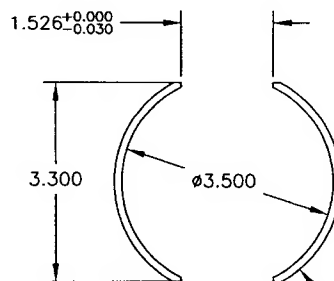
VIEW BB-BB
(SCALE 1:3)



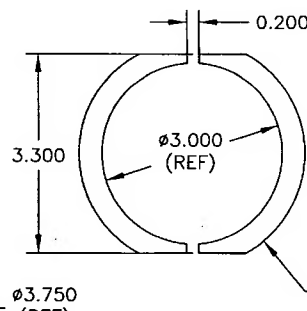
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



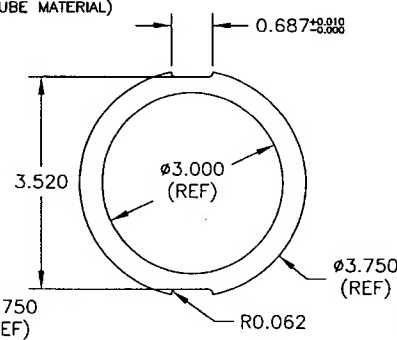
DETAIL V
(SCALE 1:2)



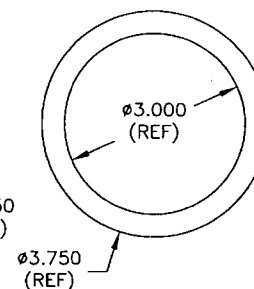
SECTION AA-AA
(SCALE 1:2)



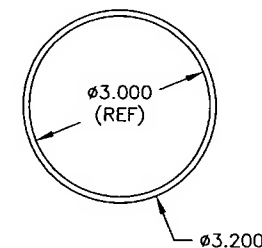
SECTION N-N
(SCALE 1:2)



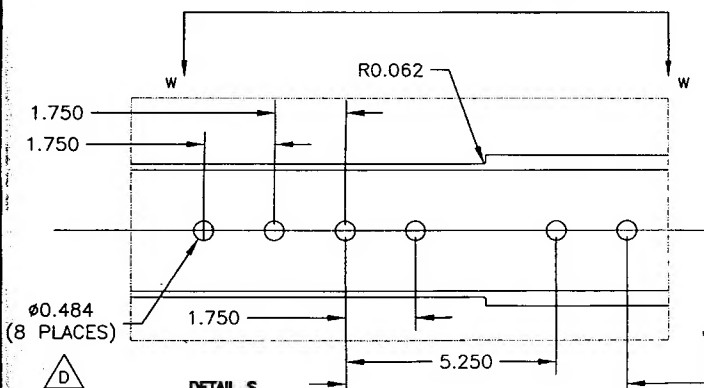
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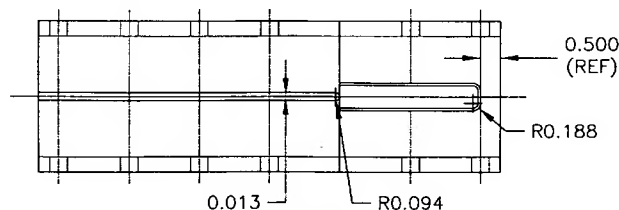
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

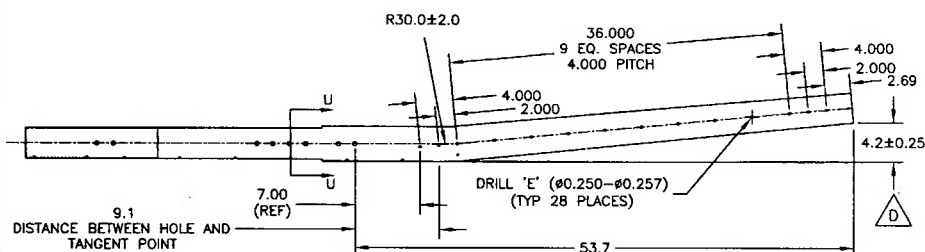
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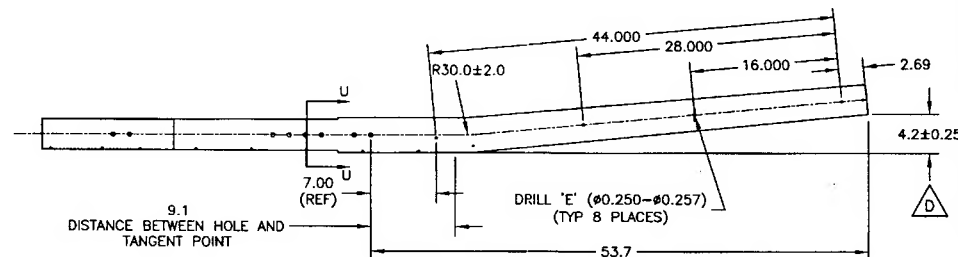
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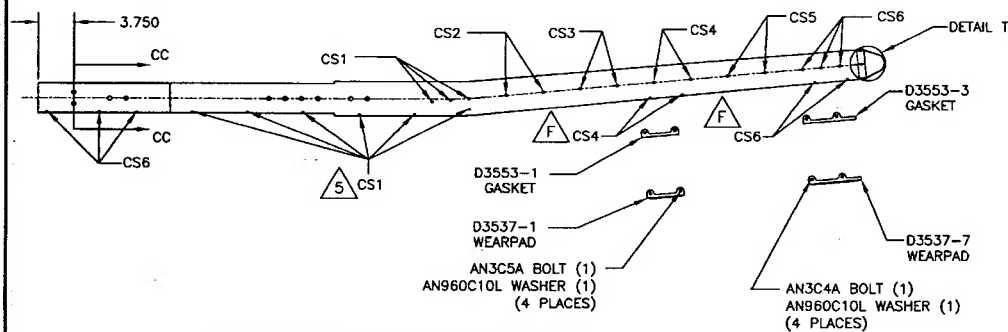
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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE	SCALE 1:12



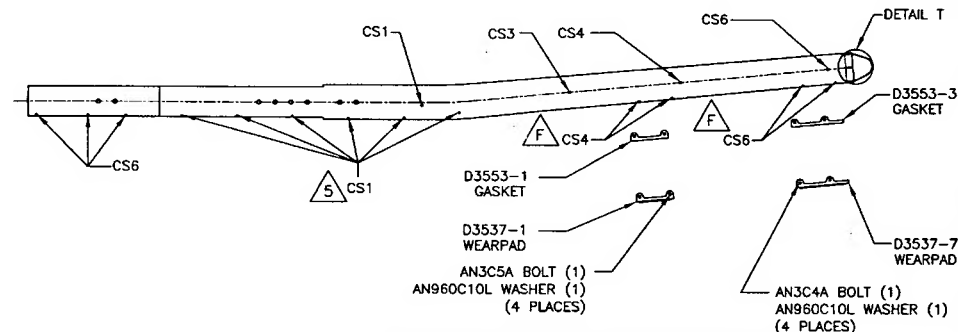
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

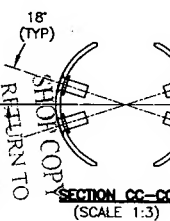


D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

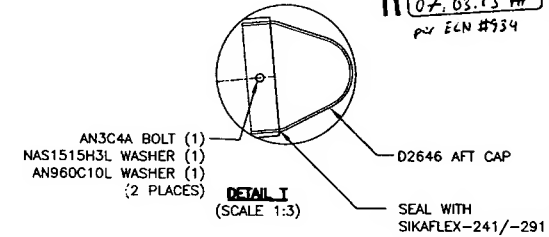
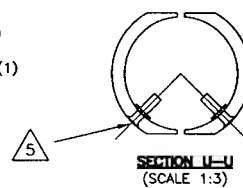
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

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DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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